

Date: Wednesday, 5/16/2007 1:40:57 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WASHER  
Job Number : 32409  
Estimate Number : 11314  
P.O. Number : *N/A*  
This Issue : 5/16/2007 S.O. No. : *N/A*  
Prsht Rev. : NC  
First Issue : *N/A* Type : MACHINED PARTS  
Previous Run : 31933  
Written By :  
Checked & Approved By : *[Signature]*  
Comment : Est. A 05.10.03 New issue KJ/JLM

Part Number : D34571  
Drawing Number : D3457 REV A  
Project Number : N/A  
Drawing Revision : A  
Material : *N/A*  
Due Date : 5/31/2007 Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MDELRLNR1000 Delrin Round Bar 1"



Comment: Qty.: 0.0218 f(s)/Unit Total : 0.8736 f(s)

Delrin Round Bar 1"

Material: Delrin Round Bar Ø1.000

(M-DELRLN-R1.000)

Batch: *104346*

Identify for D3457-1

*1.375 ft*

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Turn as per Folio FA589 Rev: *A* & Dwg D3457 Rev: *A*

*x 60*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment:

Machine as per Folio FA589 Rev: *AA* & Dwg D3457 Rev: *A*

*60*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*38 07.07.03*

*60*

5.0 QC8 SECOND CHECK


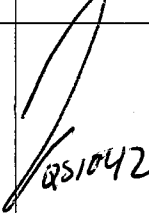


Comment: SECOND CHECK

*JL 07/07/03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: R2 Date: 07/07/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-07-03	3	Undercut on parts (x2)  Root cause: wrong Tools in file	 07/07/04	Scrap and Destroy wrong tools listed on folio. Changes made	BG 07-07-04	En 07/07/04	 07/07/04	En 07/07/04

NOTE: Date & initial all entries

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 32409

Part Number: D34571

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD 07/07/03

57 counted

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 54

07/07/04 (57)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(57)

Comment: FINAL INSPECTION/W/O RELEASE

07/07/04

Job Completion



WOT 07.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

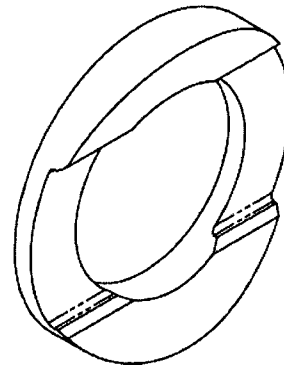
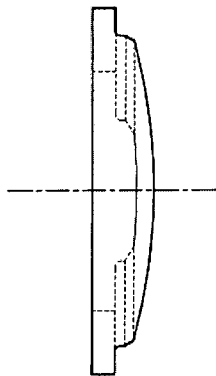
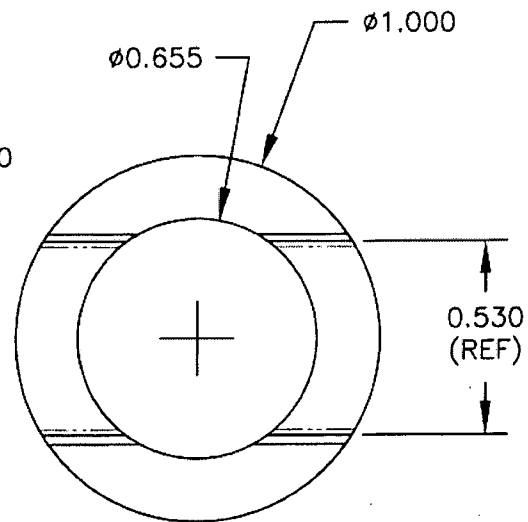
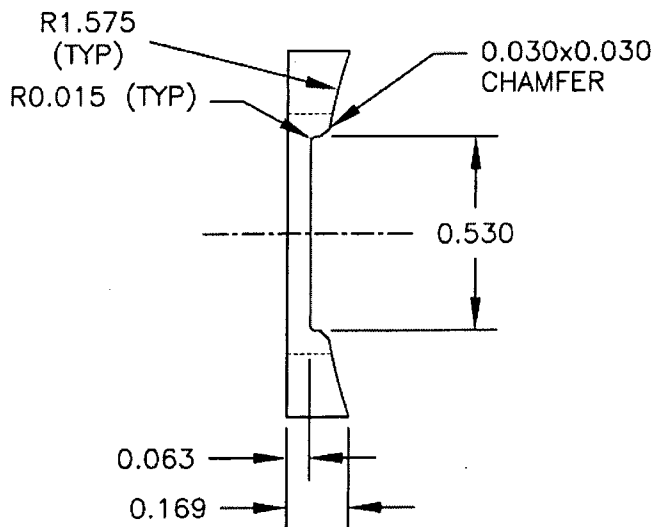
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3457	REV. A SHEET 1 OF 1
DATE 05.09.06		TITLE WASHER	SCALE 2:1
A	05.09.06	NEW ISSUE	

RELEASED  
05.09.06**ISOMETRIC DETAIL****D3457-1 WASHER**

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32409

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DART AEROSPACE LTD		Work Order:	32409
Description: Washer		Part Number:	D34571
Inspection Dwg:	Rev:		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by: <i>[Signature]</i>	Audited by: <i>J.L.</i>	Prototype Approval:
Date: <i>07/06/03</i>	Date: <i>07/07/03</i>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	